

# MANUFACTURER'S DATA REPORT FOR UNFIRED PRESSURE VESSELS

FORM U-1

Approved For Release 1999/08/27 : CIA-RDP78-04133A000100060013-1

1. Manufactured by Ralph E. Manna Co. 1030 E. Anaheim St. Wilmington, California  
(Name and address of the manufacturer) 25X1A6a
2. Manufactured for Government Radio Monitoring Station,  
(Name and address of the purchaser)
3. Type Horizontal Unfired Pressure Vessel No. (1953-34) (Nat'l Bd. No. 1953  
(Horizontal or Vertical) (Mfrs. Serial, or A.S.M.E. No.) (State and State No.)
4. Have mill test reports been checked on all plates entering this unfired pressure vessel Yes, Shell ASTM-A53 Grade B  
Do the chemical and physical properties of all plates meet the requirements of the Code Vogt Heads A285 Grade C
5. SHELL OR DRUMS: No. 1 Diameter 1 ft. 4 in. Length over all 4 ft. 0 in. Height 0 ft. 0 in.  
(or width)
6. STAMPS on shell plates A-53, 60,000# Rivets, stays and braces (Iron or Steel)  
(Brand and lowest tensile strength)
7. SHELL PLATES 5/16 in. Butt Straps Seamless Girth Fusion UW52B  
(Outer Thickness) (Thickness) (Riveted, Forge Welded, Brazed or Fusion Welded—Par. No.)
8. Diameter of rivet holes 1/8 in. Pitch of rivets X X Efficiency of joint 100 %
9. GIRTH JOINTS 1/8 in. Diameter rivet holes 1/8 in. Pitch of rivets 1/8 in. No. of courses 1  
(Single or double riveted)
10. INNER SHELL 5/16 in. Style of seams: Longitudinal Seamless Girth Fusion UW52B  
(Thickness) (Riveted, Forge Welded, Brazed or Fusion Welded—Par. No.)
11. HEADS; flat or dished 375 in. Radius of dish Concave Side to pressure Concave  
(Thickness) (Concave or Convex)

If removable, bolts used (Number and Size) or method of fastening (Describe or Sketch)

12.	STAYS	No.	Size	Net Area	Welded or Weldless	Area to be Stayed	Maximum Allowable Working Pressure
(a)	F.H.						
(b)	R.H.						
(c)	Through						
(d)	Diagonal and Gusset Stays						

13. STAYBOLTS (Iron or Steel) If hollow (Size of Hole) 14. Maximum pitch X Diameter 1/8 in.  
(Horizontal) (Vertical) (Over the threads)
15. SAFETY VALVE outlets: No. 1 Size 3/4"
16. FUSIBLE PLUG (if used): No. 2 - 1-5/8", 3 - 1-1/2", 1 - 3/4" Location (Over the threads)
17. OUTLETS: No. 6 Size 2 - 1-5/8", 3 - 1-1/2", 1 - 3/4" Material of nozzle or reinforcement (Riveted, Welded, etc.) How attached (Riveted, Welded, etc.)
18. DRAIN connection (Size) in. HAND HOLES OR SIGHT HOLES (Number, size and location)
19. MANHOLES: (Number) (Size and Location of each) Reinforcement (Riveted, Welded, etc.)
20. NONPRESSURE PARTS: (a) Supporting lugs (Number) Supporting skirts (Kind and Number) (b) Other nonpressure parts (Kind and Number)  
(c) Where and how attached (Kind and Number)
21. Bursting pressure 2380 lbs. p. s. i. Hydrostatic test 700 lbs.
22. Constructed for pressure of 250 lbs. p. s. i. Factor of safety 9.5
- Remarks: Freon 12 Refrigerant Receiver Sketch C 717-2  
(Vessel to be used for air, gas ammonia, etc.)

We certify the above data to be correct and that all details of material and construction and workmanship on this unfired pressure vessel conform to the A.S.M.E. Code for Unfired Pressure Vessels.

Date December 31 19 55 Approved For Release 1999/08/27 : CIA-RDP78-04133A000100060013-1

Certificate of Authorization Expires December 31 19 55

HOFFMAN PRESS - 8049 E. 4th St., Los Angeles 68, California - ANGELUS 1-8737

**CERTIFICATE OF SHOP INSPECTION**

Insurance Company's Serial Number.....

VESSEL MADE BY RALPH E. MANNS CO. at Wilmington, California

I, the undersigned, holding a certificate of competency as an inspector of steam boilers in THE STATE OF California and employed by the Dept. of Bldg. & Safety of Los Angeles

inspected internally and externally, the vessel specified in this report, on December 21 19 53,  
and certify that the statements made on this report are correct, corresponding with the mill test reports of material as furnished by the builders, and measurements made of the vessel when completed; and that this vessel is constructed in accordance with the A.S.M.E. Boiler Code Rules for the Construction of Unfired Pressure Vessels.

*W. J. Miller 682*  
Inspector for State or Boiler Insurance Company.

**CERTIFICATE OF FIELD ASSEMBLY INSPECTION**

I, the undersigned, Inspector of pressure vessels employed by.....  
.....of....., have compared the statements in this manufacturer's data report  
with the completed vessel and certify that parts referred to as Data Items.....  
....., not included in certificate of shop inspection, are in accordance with the requirements of the  
A.S.M.E. Code for Unfired Pressure Vessels. The completed vessel was inspected and subjected to a hydrostatic test of.....lb.  
per sq. in.

DATE.....19..... Commissions.....  
Inspector State or N. B. and No.